

Date: Tuesday, 23/09/2008 10:21:39 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LH ACTUATOR ASSEMBLY
Job Number :	42218		
Estimate Number :	12761		
P.O. Number :		Part Number :	41232 200 001 001
This Issue :	23/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	41232-200-001 REV IR
First Issue :	//	Project Number :	N/A
Previous Run :	39174	Drawing Revision :	IR
	Type :	Material :	
	SMALL /MED FAB	Due Date :	20/10/2008
Written By :		Qty:	2 Um: Each
Checked & Approved By :	JLD 08.9.23		
Comment :	Est Rev:A New Issue 07-02-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS208224	elbow
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

elbow

Batch: M104427

SP

2.0	AN8424D	Elbow
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Elbow

Batch: M108471

SP

3.0	41232 200 007 001	Brass Cylinder Assembly
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Brass Cylinder Assembly

Batch: 42266

8/10/29

SP

4.0	MS1699623	cap screw
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

cap screw

Batch: M103934

SP

5.0	AN3154R	Nut
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Nut

Batch: M17566

8/10/28

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 AN960JD416 Washer



Comment: Qty.: 2 Each(s)/Unit Total: 4 Each(s)

Washer

Batch: M108887

SP

7.0 AN960JD10 Washer



Comment: Qty.: 2 Each(s)/Unit Total: 4 Each(s)

Washer

Batch: M109039

SP

8.0 MS21042L3 Nut



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

Nut

Batch: M109031

SP

9.0 AN322A Bolt



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

Bolt

Batch: B3413 M106043

SP

10.0 41232 200 005 003 Spacer (Step Actuator)



Comment: Qty.: 2 Each(s)/Unit Total: 4 Each(s)

Spacer (Step Actuator)

Batch: B39218

SP

dit rest
2

110 41232 200 002 005 pivot arm



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

pivot arm

Batch: B39217 B 31778

SP

12.0 41232 200 002 003 latch



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

latch

Batch: B39216

sl/ro/aa

(2x)

SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 42218

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 002 001

tube



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s) (1)

tube

Batch: B30507 M31776 B42265 (1) SP

14.0

41232 200 008 001

Decal



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

Decal

Batch: B31623 SP

15.0

S 1455

spring-step actuator (replaces 71459)



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

spring-step actuator (replaces 71459)

BATCH: M104079 8/10/22 SP

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 08/11/07 (2)

17.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

108.11.11 (2)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3464 8/11/11 SL

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/11 MF

Job Completion



MF 08-11-11

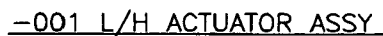
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

NO-120218

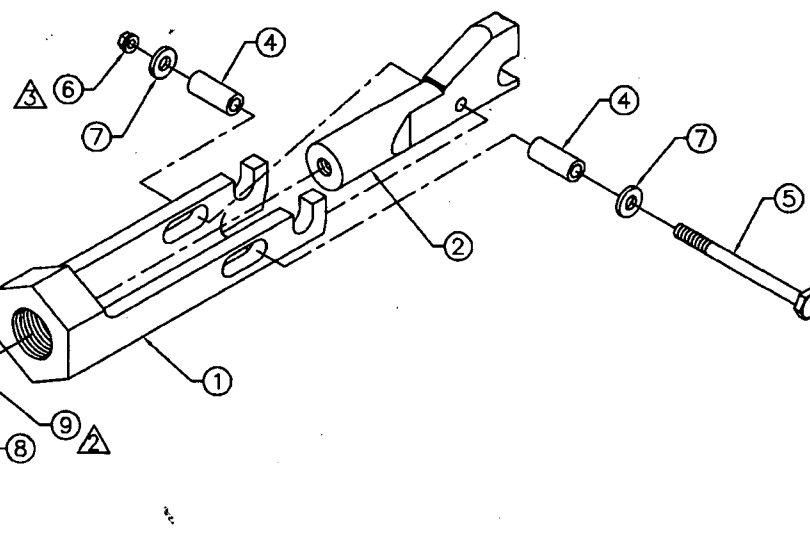
WORK ORDER

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

ENGINEERING

RETURN TO

SHOP COPY



			1	1	15	3/4x20 BRASS	CYLINDER NUT				
			1	1	14	MS20822-4	ELBOW				
			1	1	13	AN842-4D	ELBOW				
			1	1	12	41232-200-007-001	CYLINDER				
			1	1	11	71459	SPRING				
			1	1	10	MS16996-23	CAP SCREW				
			1	1	9	AN315-4R	NUT				
			2	2	8	AN960JD416	WASHER				
			2	2	7	AN960JD10	WASHER				
			1	1	6	MS21042-L3	NUT				
			1	1	5	AN3-22A	BOLT				
			2	2	4	41232-200-005-003	SPACER				
			1	1	3	41232-200-002-005	PIVOT ARM				
			1	1	2	41232-200-002-003	LATCH				
			1	1	1	41232-200-002-001	TUBE				
			/			-002	R/H ACTUATOR ASSY				
			/			-001	L/H ACTUATOR ASSY				
			-002	-001	END NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE

NO.	REQ'D	PER ASSY
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100	1	1

LIST OF MATERIAL

**PROPRIETARY
RIGHTS NOTICE**

THESE DATA ARE PROPRIETARY TO ERA ACTION, INC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA ACTION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.

002	1	41232-000-001
001		

NEXT ASSEMBLY

UNLESS
OTHERWISE
SPECIFIED
X \pm .1
XX \pm .03
XXX \pm .010
ANGLES
 \pm 1/2°

DRIFTSMM
CHECK
STRESS
PROJ. ENGR.
HEAT TREAT
FINISH

D. NELSON	5/20/02
D. MURPHY	5/20/02

Erin

DATE	TITLE
10/1/78	10/1/78
10/2/78	10/2/78
10/3/78	10/3/78
10/4/78	10/4/78
10/5/78	10/5/78
10/6/78	10/6/78
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10/28/78	10/28/78
10/29/78	10/29/78
10/30/78	10/30/78
10/31/78	10/31/78

STEP ACTUATOR ASSY

DWG. SIZE	C
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SCALE	NONE
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DNG. NO.

41232-200-001

REV.

IR

W/O:		WORK ORDER CHANGES					
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